

Date: Wednesday, 3/8/2006 10:33:25 AM
 User: Kim Johnston

Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
 Job Number : 26098
 Estimate Number : 10266
 P.O. Number : N/A Part Number : D350636013
 This Issue : 3/8/2006 S.O. No. : N/A Drawing Number : D2750 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C1
 Previous Run : 26097 Material : N/A
 Written By : SEE COMMENT Below Due Date : 4/15/2006 Qty: 1 Um: Each
 Checked & Approved By : KJ 06-03-08
 Comment : Est Rev:H 02-09-25 Rearranged procedure steps KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 001

DA 06/03/21

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent)

B25384 Pm' 06-03-09

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2744 Cap

B24672 BE 06-03-27

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end

Pm' 06-03-09

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-3) and mark fwd end for cutting using Drill Jig DT

Pm' 06-03-09

8150. Second side of Detail B to be Drilled using DT-8330

*****Drill last hole using Dt 8820 locating off last hole drilled*****

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO
 9133 Do not open any 0.625" AE holes to finished size

Pm' 06-03-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-3),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides.

Pm' 06-03-22①

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330

Make sure that wearplate holes are on bottom of tube**

Pm' 06-03-22①

6-Open holes to .500" as per detail "B&C".

Pm' 06-03-22①

7-Open holes to .375"mas per detail "D"

Pm' 06-03-22①

8-Cut fwd end of tube as per Dwg D2750

Pm' 06-03-22①

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail

A

Pm' 06-03-22①

10-Open holes to .391" as per detail "D".

Pm' 06-03-22①

11-Deburr

Pm' 06-03-22①

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R

Aluminum Rod

M19100 BE 06-03-27①

13-Grind welds flush as per Dwg D2750

BE 06-03-28①

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm' 06-03-28①

6.0

QC5/9

WELD INSPECTION



PD 06-03-28

DP 06-3-29



Comment: WELD INSPECTION

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2739

Web

B26395

Pm' 06-03-29①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26098

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

B-24641 BE 06-03-30 (1)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil

2-Deburr and blow out all chips from inside of tube

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

Sikaflex expire date: 06-11-01

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

5-Grind welds flush as per Dwg D2750

6-Spot face ground handling holes AE0.750" (8 places)

7-Deburr holes

10.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
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Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D27421	Blade Fitting, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-1	Blade Fitting, LH	B25111

14.0	AN835A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

15.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	G956

16.0	MS21083N8	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19099

17.0	D26483	Wearpad
------	--------	---------



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B24843-2

18.0	D265613	Wearplate
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B25914

DL 02/05/02 (1)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26098

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

19.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2656-35	Wearplate

Batch

B25330 /

20.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2746	Wearplate

Batch

B25841 /

21.0

ALS41032225

Insert



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description
46	ALS4-1032-225 ✓	Insert
	(or AKS4-1032-225)	
	(or ALS7-1032-225)	
	(or AKS7-1032-225)	

Batch

M18293 /

22.0

AN960JD10L

Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description
42	AN960JD10L	Washer

Batch

M18235 /

23.0

AN35A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description
38	AN3-5A	Bolt

Batch

M15205

DL 06/05/02 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 26098

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

24.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN3-6A Bolt M100274 ✓

25.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 D2745 Bushing B24879 ✓

26.0 AN644A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN6-44A Bolt M19471 ✓

27.0 MS21042L6 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 MS21042L6 Nut (or -6) M17614 ✓

28.0 AN36A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN3-6A Bolt M100274

DL 06/05/02 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 26098

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description
4	AN960JD10	Washer

Batch

M16066

DL 06/05/02 (1)

30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291

M100480

Sikaflex expire date: 11/06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.

A/R Sikaflex-291

M100480

Sikaflex expire date: 11/06

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

DL 06/05/02 (1)

31.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

32.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

33.0	D2741	Blade
------	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

B25938 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DD* Date: 06/05/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26098

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

516956 ✓

35.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

5119099 ✓

36.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

MS760

AR 06/05/03 (1)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/05/03 (1)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev D

AR 06/05/03 (1)

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/04 (1)

Job Completion



u 06/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.12.16 DS

DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
C1	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
40	40	40	40	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
44	44	44	44	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
44	44	44	44	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT
42	42	42	42		

EFFECTIVE	DEOS
Dec 4 1998 DS	Dec 9 1998 DS
98.01.19 DS	98.10.21 DS

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WITHOUT NOTICE
WORK ORDER

NO. 26098



DESIGN <i>JA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>JA</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

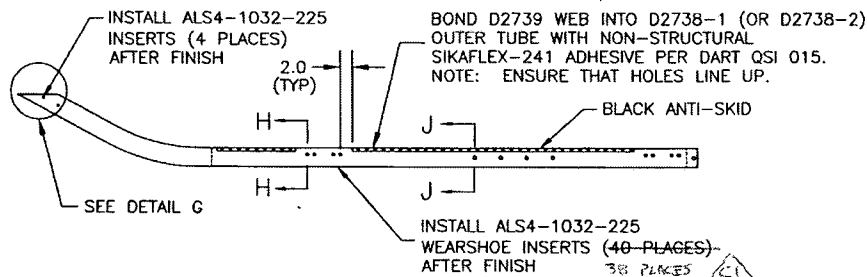
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 4157 99.10.21 DS

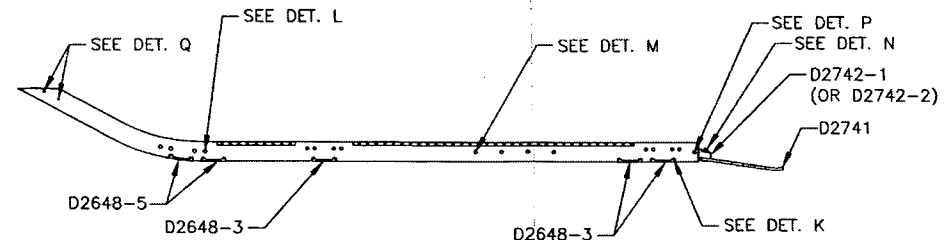
RELEASED
98.12.16 DS

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WITHOUT NOTICE
WORK ORDER
NO. 26098

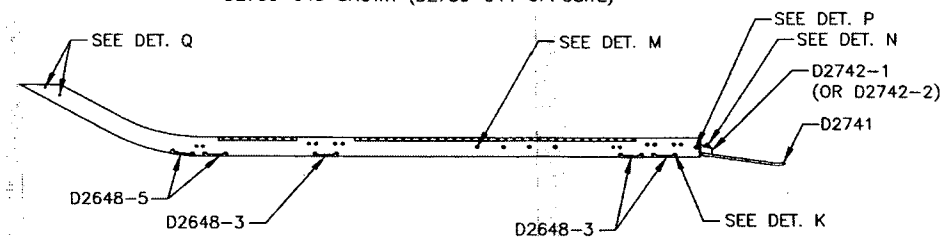
D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



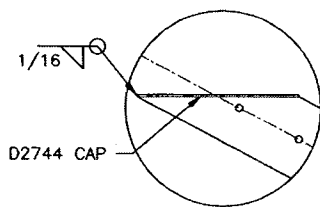
D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)



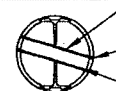
D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)



DETAIL G

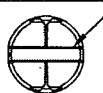


SECTION H-H



(TYP)

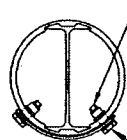
SECTION J-J



WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

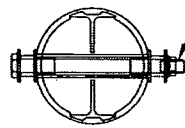
DETAIL K



USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD

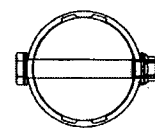
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)

DETAIL M



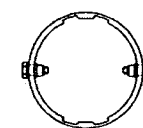
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)

DETAIL P



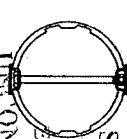
AN8-35A BOLT (1)
AN960JDB16 WASHER (2)
MS21083N8 NUT (1)

DETAIL Q



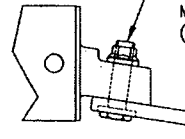
AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)

DETAIL L



AN3-32A BOLT (1)
A3235-020-935 PLUG (2)
MS21042L3 NUT (1)
(4 PLACES, FOR D2750-041/-042 ONLY)

DETAIL N



AN8-16A BOLT (1)
AN960JDB16 WASHER (1)
MS21083N8 NUT (1)
(2 PLACES)

EFFECTIVE	DEOs
DES 9/33 98.01.19 DS	DES 9/57 99.10.21 DS

DESIGN #1	DRAWN BY CP	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED #1	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY
		REV. C SHEET 4 OF 4 SCALE 1:20

RELEASED
98.12.16 DS

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